



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D2938-1BL**  
**Job Sheet 167807-A**



**Part No:** D2938-1BL

**Job Qty:** 5 ea

**Part Name:** Saddle LH Out, 206



**Part Weight:** 0 lbs

**Status:** Scheduled

**Priority:** High

**Job Created:** 12/12/17

**Job Tracking No:**

**Due Date:** 11/24/17

**Created By:** Linda Lacelle

**Type:** SOLD

**Description:**

**Ship Via:**

*not painted  
Blue.*

### Bill of Materials

### Job Routing

| Op No | Operation  | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |            |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 130   | QC         | 5 pcs |            | 11/23/17 | 0.00      | 0.00    | QC8 Machining-1       |           |          |
| 140   | HandFinish | 5 pcs |            | 11/24/17 | 0.00      | 0.13    | HandFinish1           |           |          |
| 150   | Outsource  | 5 pcs |            | 11/24/17 |           |         | ATE003-VC             |           |          |
| 160   | QC         | 5 pcs |            | 11/24/17 | 0.00      | 0.00    | QC14                  |           |          |
| 170   | Packaging  | 5 pcs |            | 11/24/17 | 0.00      | 0.00    | Packaging3-1          |           |          |
| 180   | QC21-SA    | 5 Ea  |            | 11/24/17 | 0.00      | 0.00    | QC21                  |           |          |

Part Op Descriptions: 150 - \*\*\*MASK ALL HOLES AS PER PAR16-484\*\*\* ISSUE PO

### Job Allocations

Job Allocations could not be found.

### Part Specifications

Specifications could not be found.

Plex 12/12/17 9:16 AM dart.lacelle.linda

*See w/o 172363.*

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_



Work Order update only ☐

|                   |                                                                         |
|-------------------|-------------------------------------------------------------------------|
| Work Order: _____ | DISPOSITION<br><br>Rework<br>Scrap<br>Use-as-is<br>Suspected Unapproved |
| Part No. _____    |                                                                         |
| NCR No. _____     |                                                                         |

|             |               |
|-------------|---------------|
| Date: _____ | Step #: _____ |
|-------------|---------------|

Description Work Order Deviation

|  |
|--|
|  |
|--|

**Dart Aerospace Ltd.**  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL: 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com



Saddle LH Out, 206

**D2938 - 1BL**

**QC**

**PART NO:**  
**Revision:**  
**Operation:**  
**Change No:**

**Mfg Date: 12/12/17**  
**Job No: 167807 - A**

|                                      |                                      |
|--------------------------------------|--------------------------------------|
| PROCESS                              |                                      |
| Water Jet <input type="checkbox"/>   | Engineering <input type="checkbox"/> |
| Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/>     |
| Packaging <input type="checkbox"/>   | Other <input type="checkbox"/>       |
| Supplier <input type="checkbox"/>    |                                      |

MRB (QSI042) Approval

|  |
|--|
|  |
|--|

Completed By

Lead hand / Supervisor  
Approval Verification

QC / QA Coordinator  
Approval

| Root Cause                                  |                          |                       |                          |
|---------------------------------------------|--------------------------|-----------------------|--------------------------|
| Environment <input type="checkbox"/>        | <input type="checkbox"/> | No Re-verification    | <input type="checkbox"/> |
| Design <input type="checkbox"/>             | <input type="checkbox"/> | Operator              | <input type="checkbox"/> |
| Doc/Data <input type="checkbox"/>           | <input type="checkbox"/> | Offset/Setup          | <input type="checkbox"/> |
| Equip/Tooling <input type="checkbox"/>      | <input type="checkbox"/> | Supplier              | <input type="checkbox"/> |
| Handling/Pre <input type="checkbox"/>       | <input type="checkbox"/> | Training              | <input type="checkbox"/> |
| Material <input type="checkbox"/>           | <input type="checkbox"/> | Use for Testing       | <input type="checkbox"/> |
| Internal Transport <input type="checkbox"/> | <input type="checkbox"/> | Poor Information      | <input type="checkbox"/> |
| Tribal Knowledge <input type="checkbox"/>   | <input type="checkbox"/> | Rushing               | <input type="checkbox"/> |
| LOA <input type="checkbox"/>                | <input type="checkbox"/> | Product Improvement   | <input type="checkbox"/> |
| Substation <input type="checkbox"/>         | <input type="checkbox"/> | Process Improvement   | <input type="checkbox"/> |
| Past Expiry Date <input type="checkbox"/>   | <input type="checkbox"/> | Manufacturing Process | <input type="checkbox"/> |
| Misidentified <input type="checkbox"/>      | <input type="checkbox"/> | Past Due              | <input type="checkbox"/> |

|                          |                        |
|--------------------------|------------------------|
| <input type="checkbox"/> | Pressure/Forced        |
| <input type="checkbox"/> | Bending                |
| <input type="checkbox"/> | Centre Not Concentric  |
| <input type="checkbox"/> | Cracks                 |
| <input type="checkbox"/> | Crimp/Kink/Ripple/Wave |
| <input type="checkbox"/> | Cuffs                  |
| <input type="checkbox"/> | Crushing               |
| <input type="checkbox"/> | Heat Treat             |
| <input type="checkbox"/> | Wave/Twist in Tube     |
| <input type="checkbox"/> | Marks/Chatter          |

|                          |                                 |
|--------------------------|---------------------------------|
| <input type="checkbox"/> | Cut Too Short                   |
| <input type="checkbox"/> | Instructions Incomplete/Unclear |
| <input type="checkbox"/> | Drill Holes                     |

|                          |                       |
|--------------------------|-----------------------|
| <input type="checkbox"/> | Mislabeled            |
| <input type="checkbox"/> | Fit/Function          |
| <input type="checkbox"/> | Misaligned/off center |

|              |                          |                      |
|--------------|--------------------------|----------------------|
| rge          | <input type="checkbox"/> | Positioned Wrong     |
|              | <input type="checkbox"/> | Outside Dimensions   |
|              | <input type="checkbox"/> | Over/Under tolerance |
|              | <input type="checkbox"/> | Part Incorrect       |
| 'ulled<br>ce | <input type="checkbox"/> | Part Lost/Missing    |
|              | <input type="checkbox"/> | Part Moved           |
|              | <input type="checkbox"/> | Drawing              |
|              | <input type="checkbox"/> | Finish               |
|              | <input type="checkbox"/> | Misread              |
|              | <input type="checkbox"/> | Turning Sequence     |

OTHER :





Dart Hawkesbury  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D2938-1BL**

**Job Sheet 167807**



Part No: D2938-1BL

Job Qty: 10 ea *5*

Part Name: Saddle LH Out, 206



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/7/17

Job Tracking No:

Due Date: 11/24/17

Created By: Victoria Michaud-Febrille

Type: SOLD

Description:

Ship Via:

*Rev C.*

### Bill of Materials

### Job Routing

| Op No          | Operation              | Qty               | Start Date          | Due Date            | Standard        |                 | Workcenter/Supplier   |           | Sign-off                |
|----------------|------------------------|-------------------|---------------------|---------------------|-----------------|-----------------|-----------------------|-----------|-------------------------|
|                |                        |                   |                     |                     | Setup hrs       | Run Hrs         | Workcenter / Supplier | Lead Time |                         |
| 90             | Start up Operation     | 10 Ea             | 11/22/17            | 11/22/17            | 0.00            | 0.00            | Start Up Machining    |           |                         |
| 100            | CNC Vertical Machining | 10 pcs            | 11/23/17            | 11/23/17            | 0.69            | 13.27           | HAAS 1                |           | SBL 01/12/17            |
| 110            | Mill Conv              | 10 pcs            | 11/23/17            | 11/23/17            | 0.00            | 13.27           | Mill Conv 1           |           | SBL 01/12/17            |
| <del>120</del> | <del>QC</del>          | <del>10 pcs</del> | <del>11/23/17</del> | <del>11/23/17</del> | <del>0.00</del> | <del>0.00</del> | <del>QC1</del>        |           | <del>SBL 01/12/17</del> |
| 130            | QC                     | 10 pcs            | 11/23/17            | 11/23/17            | 0.00            | 0.00            | QC8                   |           | mmL 17/12/17            |
| 140            | HandFinish             | 10 pcs            | 11/23/17            | 11/23/17            | 0.00            | 0.26            | HandFinish1           |           |                         |
| 150            | SprayPaint             | 10 pcs            | 11/24/17            | 11/24/17            | 0.00            | 0.86            | Spray Paint           |           |                         |
| 160            | QC                     | 10 pcs            | 11/24/17            | 11/24/17            | 0.00            | 0.00            | QC14                  |           |                         |
| 170            | Packaging              | 10 pcs            | 11/24/17            | 11/24/17            | 0.00            | 0.00            | Packaging3            |           |                         |
| 180            | QC21-SA                | 10 Ea             | 11/24/17            | 11/24/17            | 0.00            | 0.00            | QC21                  |           |                         |

Part Op 100 - Program part number and batch number.

Descriptions: 110 - Machine Keyway and inspect per attached dimension sheet

150 - \*\*\*MASK ALL HOLES AS PER PAR16-484\*\*\*

### Job Allocations .

| Operation             | Component Part | Required | Inventory | Allocated | Std Qty |
|-----------------------|----------------|----------|-----------|-----------|---------|
| 90-Start up Operation | D6101-003      | 10       | 18        | 0         | 0       |

*5015243*

### Part Specifications

Specifications could not be found.

Plex 11/7/17 8:22 AM dart.Michaud-Febrille.Victoria

|                                                     |                             |
|-----------------------------------------------------|-----------------------------|
| <b>DART AEROSPACE LTD</b>                           | <b>Work Order:</b> 167807   |
| <b>Description:</b> 206 Saddle, Outboard, Left side | <b>Part Number:</b> D2938-1 |
| <b>Inspection Dwg:</b> D2938 Rev. C                 | <b>Page 1 of 1</b>          |

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

| Dim           | Min   | Max   | Go/No Go Gauge | Recorded Actual Dimensions |       |       |       | By  | Date     |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|-----|----------|
|               |       |       |                | 1 5                        | 2 6   | 3 7   | 4 8   |     |          |
| A             | 0.100 | 0.140 |                | .128                       | .120  | .128  | .130  | SBL | 30/11/17 |
| B             | 0.100 | 0.140 |                | .128                       | .128  | .128  | .128  |     |          |
| C             | 0.100 | 0.140 |                | .112                       | .113  | .111  | .113  |     |          |
| D             | 0.210 | 0.230 |                | .225                       | .225  | .226  | .226  |     |          |
| E             | 1.245 | 1.255 |                | 1.250                      | 1.250 | 1.250 | 1.250 |     |          |
| F             | 1.245 | 1.255 |                | 1.250                      | 1.250 | 1.250 | 1.250 |     |          |
| G             | 2.495 | 2.505 |                | 2.500                      | 2.500 | 2.500 | 2.500 |     |          |
| H             | 0.510 | 0.515 |                | .514                       | .514  | .514  | .514  |     |          |
| I             | 1.572 | 1.582 |                | 1.577                      | 1.577 | 1.577 | 1.577 |     |          |
| J             | 2.495 | 2.505 |                | 2.500                      | 2.500 | 2.500 | 2.500 |     |          |
| K             | 0.257 | 0.262 |                | .257                       | .257  | .257  | .257  |     |          |
| L             | 0.312 | 0.317 |                | .312                       | .312  | .312  | .312  |     |          |
| M             | 0.235 | 0.240 |                | .237                       | .238  | .237  | .238  |     |          |
| N             | 0.100 | 0.140 |                | .120                       | .121  | .121  | .121  |     |          |
| O             | 0.540 | 0.560 |                | .550                       | .550  | .550  | .550  |     |          |
| P             | 0.490 | 0.510 |                | .500                       | .500  | .500  | .500  |     |          |
| Q             | 3.715 | 3.725 |                | 3.720                      | 3.720 | 3.720 | 3.720 |     |          |
| R             | 2.720 | 2.760 |                | 2.740                      | 2.740 | 2.740 | 2.740 |     |          |
| S             | 0.240 | 0.270 |                | .257                       | .257  | .258  | .257  |     |          |
| T             | 0.100 | 0.180 |                | .140                       | .140  | .140  | .140  |     |          |
| U             | 1.625 | 1.635 |                | 1.630                      | 1.630 | 1.630 | 1.630 |     |          |
| V             | 1.362 | 1.372 |                | 1.367                      | 1.367 | 1.367 | 1.367 |     |          |
| W             | 0.316 | 0.321 |                | .316                       | .316  | .316  | .316  |     |          |
| X             | 1.250 | 1.270 |                | 1.260                      | 1.260 | 1.260 | 1.259 |     |          |
| Y             | 1.565 | 1.585 |                | 1.572                      | 1.573 | 1.573 | 1.573 |     |          |
| Z             | 0.178 | 0.198 |                | .188                       | .188  | .188  | .188  |     |          |
| AA            |       |       |                |                            |       |       |       |     |          |
| AB            |       |       |                |                            |       |       |       |     |          |
| AC            |       |       |                |                            |       |       |       |     |          |
| AD            |       |       |                |                            |       |       |       |     |          |
| AE            |       |       |                |                            |       |       |       |     |          |
| AF            |       |       |                |                            |       |       |       |     |          |
| AG            |       |       |                |                            |       |       |       |     |          |
| AH            |       |       |                |                            |       |       |       |     |          |
| Accept/Reject |       |       |                |                            |       |       |       |     |          |

|                  |
|------------------|
| Measured by: SBL |
| Date: 30/11/17   |

|                         |
|-------------------------|
| Audited by: [Signature] |
| Date: 17/12/17          |

| Rev | Date     | Change                                           | Revised |
|-----|----------|--------------------------------------------------|---------|
| A   |          | New Issue                                        | RF      |
| B   | 02.12.12 | Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 | KJ      |
| C   | 07.03.21 | Revised per drawing revision C                   | K       |



|                                                     |                     |             |
|-----------------------------------------------------|---------------------|-------------|
| <b>DART AEROSPACE LTD</b>                           | <b>Work Order:</b>  | 167807      |
| <b>Description:</b> 206 Saddle, Outboard, Left side | <b>Part Number:</b> | D2938-1     |
| <b>Inspection Dwg:</b> D2938 Rev. C                 |                     | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

| Dim           | Min   | Max   | Go/No Go Gauge | Recorded Actual Dimensions |       |       |       | By  | Date     |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|-----|----------|
|               |       |       |                | 1                          | 2     | 3     | 4     |     |          |
| A             | 0.100 | 0.140 |                | .130                       | .127  | .127  | .127  | SBL | 30/11/17 |
| B             | 0.100 | 0.140 |                | .130                       | .127  | .127  | .127  |     |          |
| C             | 0.100 | 0.140 |                | .113                       | .125  | .112  | .113  |     |          |
| D             | 0.210 | 0.230 |                | .225                       | .226  | .225  | .226  |     |          |
| E             | 1.245 | 1.255 |                | 1.250                      | 1.250 | 1.250 | 1.250 |     |          |
| F             | 1.245 | 1.255 |                | 1.250                      | 1.250 | 1.250 | 1.250 |     |          |
| G             | 2.495 | 2.505 |                | 2.500                      | 2.500 | 2.500 | 2.500 |     |          |
| H             | 0.510 | 0.515 |                | .514                       | .514  | .514  | .514  |     |          |
| I             | 1.572 | 1.582 |                | 1.577                      | 1.577 | 1.577 | 1.577 |     |          |
| J             | 2.495 | 2.505 |                | 2.500                      | 2.500 | 2.500 | 2.500 |     |          |
| K             | 0.257 | 0.262 |                | .257                       | .257  | .257  | .257  |     |          |
| L             | 0.312 | 0.317 |                | .312                       | .312  | .312  | .312  |     |          |
| M             | 0.235 | 0.240 |                | .238                       | .237  | .237  | .237  |     |          |
| N             | 0.100 | 0.140 |                | .121                       | .122  | .121  | .121  |     |          |
| O             | 0.540 | 0.560 |                | .550                       | .550  | .550  | .550  |     |          |
| P             | 0.490 | 0.510 |                | .500                       | .500  | .500  | .500  |     |          |
| Q             | 3.715 | 3.725 |                | 3.720                      | 3.720 | 3.720 | 3.720 |     |          |
| R             | 2.720 | 2.760 |                | 2.740                      | 2.742 | 2.740 | 2.740 |     |          |
| S             | 0.240 | 0.270 |                | .258                       | .257  | .257  | .257  |     |          |
| T             | 0.100 | 0.180 |                | .140                       | .140  | .140  | .140  |     |          |
| U             | 1.625 | 1.635 |                | 1.630                      | 1.630 | 1.630 | 1.630 |     |          |
| V             | 1.362 | 1.372 |                | 1.367                      | 1.367 | 1.367 | 1.367 |     |          |
| W             | 0.316 | 0.321 |                | .316                       | .316  | .316  | .316  |     |          |
| X             | 1.250 | 1.270 |                | 1.258                      | 1.260 | 1.260 | 1.258 |     |          |
| Y             | 1.565 | 1.585 |                | 1.572                      | 1.573 | 1.573 | 1.572 |     |          |
| Z             | 0.178 | 0.198 |                | .188                       | .188  | .188  | .188  |     |          |
| AA            |       |       |                |                            |       |       |       |     |          |
| AB            |       |       |                |                            |       |       |       |     |          |
| AC            |       |       |                |                            |       |       |       |     |          |
| AD            |       |       |                |                            |       |       |       |     |          |
| AE            |       |       |                |                            |       |       |       |     |          |
| AF            |       |       |                |                            |       |       |       |     |          |
| AG            |       |       |                |                            |       |       |       |     |          |
| AH            |       |       |                |                            |       |       |       |     |          |
| Accept/Reject |       |       |                |                            |       |       |       |     |          |

|              |          |
|--------------|----------|
| Measured by: | SBL      |
| Date:        | 30/11/17 |

|             |             |
|-------------|-------------|
| Audited by: | [Signature] |
| Date:       | 17/12/17    |

| Rev | Date     | Change                                           | Revised by | Approved    |
|-----|----------|--------------------------------------------------|------------|-------------|
| A   |          | New Issue                                        | RF         |             |
| B   | 02.12.12 | Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 | KJ/RF      |             |
| C   | 07.03.21 | Revised per drawing revision C                   | KJ/JLM     | [Signature] |

|                                                     |                     |             |
|-----------------------------------------------------|---------------------|-------------|
| <b>DART AEROSPACE LTD</b>                           | <b>Work Order:</b>  | 167807      |
| <b>Description:</b> 206 Saddle, Outboard, Left side | <b>Part Number:</b> | D2938-1     |
| <b>Inspection Dwg:</b> D2938 Rev. C                 |                     | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

|               |       |       |                | Recorded Actual Dimensions |       |   |   |     |          |
|---------------|-------|-------|----------------|----------------------------|-------|---|---|-----|----------|
| Dim           | Min   | Max   | Go/No Go Gauge | 9                          | 10    | 3 | 4 | By  | Date     |
| A             | 0.100 | 0.140 |                | .129                       | .128  |   |   | SBL | 30/11/17 |
| B             | 0.100 | 0.140 |                | .129                       | .129  |   |   |     |          |
| C             | 0.100 | 0.140 |                | .112                       | .112  |   |   |     |          |
| D             | 0.210 | 0.230 |                | .225                       | .226  |   |   |     |          |
| E             | 1.245 | 1.255 |                | 1.250                      | 1.250 |   |   |     |          |
| F             | 1.245 | 1.255 |                | 1.250                      | 1.250 |   |   |     |          |
| G             | 2.495 | 2.505 |                | 2.500                      | 2.500 |   |   |     |          |
| H             | 0.510 | 0.515 |                | .514                       | .514  |   |   |     |          |
| I             | 1.572 | 1.582 |                | 1.577                      | 1.577 |   |   |     |          |
| J             | 2.495 | 2.505 |                | 2.500                      | 2.500 |   |   |     |          |
| K             | 0.257 | 0.262 |                | .257                       | .257  |   |   |     |          |
| L             | 0.312 | 0.317 |                | .312                       | .312  |   |   |     |          |
| M             | 0.235 | 0.240 |                | .237                       | .237  |   |   |     |          |
| N             | 0.100 | 0.140 |                | .121                       | .121  |   |   |     |          |
| O             | 0.540 | 0.560 |                | .550                       | .550  |   |   |     |          |
| P             | 0.490 | 0.510 |                | .500                       | .500  |   |   |     |          |
| Q             | 3.715 | 3.725 |                | 3.720                      | 3.720 |   |   |     |          |
| R             | 2.720 | 2.760 |                | 2.740                      | 2.740 |   |   |     |          |
| S             | 0.240 | 0.270 |                | .258                       | .258  |   |   |     |          |
| T             | 0.100 | 0.180 |                | .138                       | .138  |   |   |     |          |
| U             | 1.625 | 1.635 |                | 1.630                      | 1.630 |   |   |     |          |
| V             | 1.362 | 1.372 |                | 1.367                      | 1.367 |   |   |     |          |
| W             | 0.316 | 0.321 |                | .316                       | .316  |   |   |     |          |
| X             | 1.250 | 1.270 |                | 1.260                      | 1.260 |   |   |     |          |
| Y             | 1.565 | 1.585 |                | 1.575                      | 1.575 |   |   |     |          |
| Z             | 0.178 | 0.198 |                | .188                       | .188  |   |   |     |          |
| AA            |       |       |                |                            |       |   |   |     |          |
| AB            |       |       |                |                            |       |   |   |     |          |
| AC            |       |       |                |                            |       |   |   |     |          |
| AD            |       |       |                |                            |       |   |   |     |          |
| AE            |       |       |                |                            |       |   |   |     |          |
| AF            |       |       |                |                            |       |   |   |     |          |
| AG            |       |       |                |                            |       |   |   |     |          |
| AH            |       |       |                |                            |       |   |   |     |          |
| Accept/Reject |       |       |                |                            |       |   |   |     |          |

|                  |
|------------------|
| Measured by: SBL |
| Date: 30/11/17   |

|                         |
|-------------------------|
| Audited by: [Signature] |
| Date: 17/12/17          |

| Rev | Date     | Change                                           | Revised by | Approved    |
|-----|----------|--------------------------------------------------|------------|-------------|
| A   |          | New Issue                                        | RF         |             |
| B   | 02.12.12 | Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 | KJ/RF      |             |
| C   | 07.03.21 | Revised per drawing revision C                   | KJ/JLM     | [Signature] |